Dart Aerospace Ltd.

Date: Monday, 6/25/2007 9:09:56 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B SCUFF PLATE, FWD LH UNDER REVIEW
Job Number	: 33107		
Estimate Number	: 12263		
P.O. Number	:	Part Number	: D206555001
This Issue	: 6/25/2007 S.O. No. :	Drawing Number	: D206-555 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 27932	Material	:
Written By	:	Due Date	: 7/10/2007 Qty: 10 Um: Each
Checked & Approved By	: 07.06.25		
Comment	: Est. C 99.06.29 Returned to Electro Polish DM Est Rev:D Now on Waterjet 07-06-11 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Type Labels as per PPP D206-555-001	
2.0	M304S25GA	304/316 .020" Sheet
	Comment: Qty.: 0.3591 sf(s)/Unit Total : 3.5910 sf(s) 304/316 .020" Sheet M/LB 07-06-27 ~~27-06-07~~ BATCH: M103504	M 104933 (4)
3.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D206-555 Dwg Rev: C Prog Rev: C 2-Deburr if necessary	SAD 07/08/08 (4) LB 07-08-09
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	LB 07-08-09	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	07/08/09 counted x10

P10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-555-001 **PAR #:** N/A **Fault Category:** Prod / Fab as-mod & small **NCR:** (Yes) No **DQA:** D **Date:** 08/08/01

QA: N/C Closed: _____ **Date:** _________

NCR: 33107	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action — Initial Chief Eng	Corrective Action (Section B) — Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08.01.02	5.0	Parts to be discontinued and Quarantined per NCR 241	[signature] 08/01/02	- parts to go to engineering for further investigation per NCR 241.	[signature] 08/01/02	[signature] 08.01.02	[signature] 08/01/02	[signature] 08.01.02

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:09:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206 A/B SCUFF PLATE, FWD LH UNDER REVIEW

Job Number: 33107 **Part Number:** D206555001

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Form parts on hydraulic press as per Dwg. D206-555 using DT 8314-1
Finish form on bench forming Jig DT 8315-1
Remove tooling tabs and deburr

Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
8.0	OUTSIDE SERV.20	OUTSIDE SERVICE - SF

Comment: Sub-Contracting Outside services
Electrochemically polish per ASTM B912,High shine finish,No scratchs on surfaces.
Issue P/O: __________
Possible supplier:TQF Technologies

Seq. #:	Machine Or Operation:	Description :
9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive and Inspect for transit damage

Seq. #:	Machine Or Operation:	Description :
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Seq. #:	Machine Or Operation:	Description :
11.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______

Seq. #:	Machine Or Operation:	Description :
12.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

cmF 08-04-02

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART

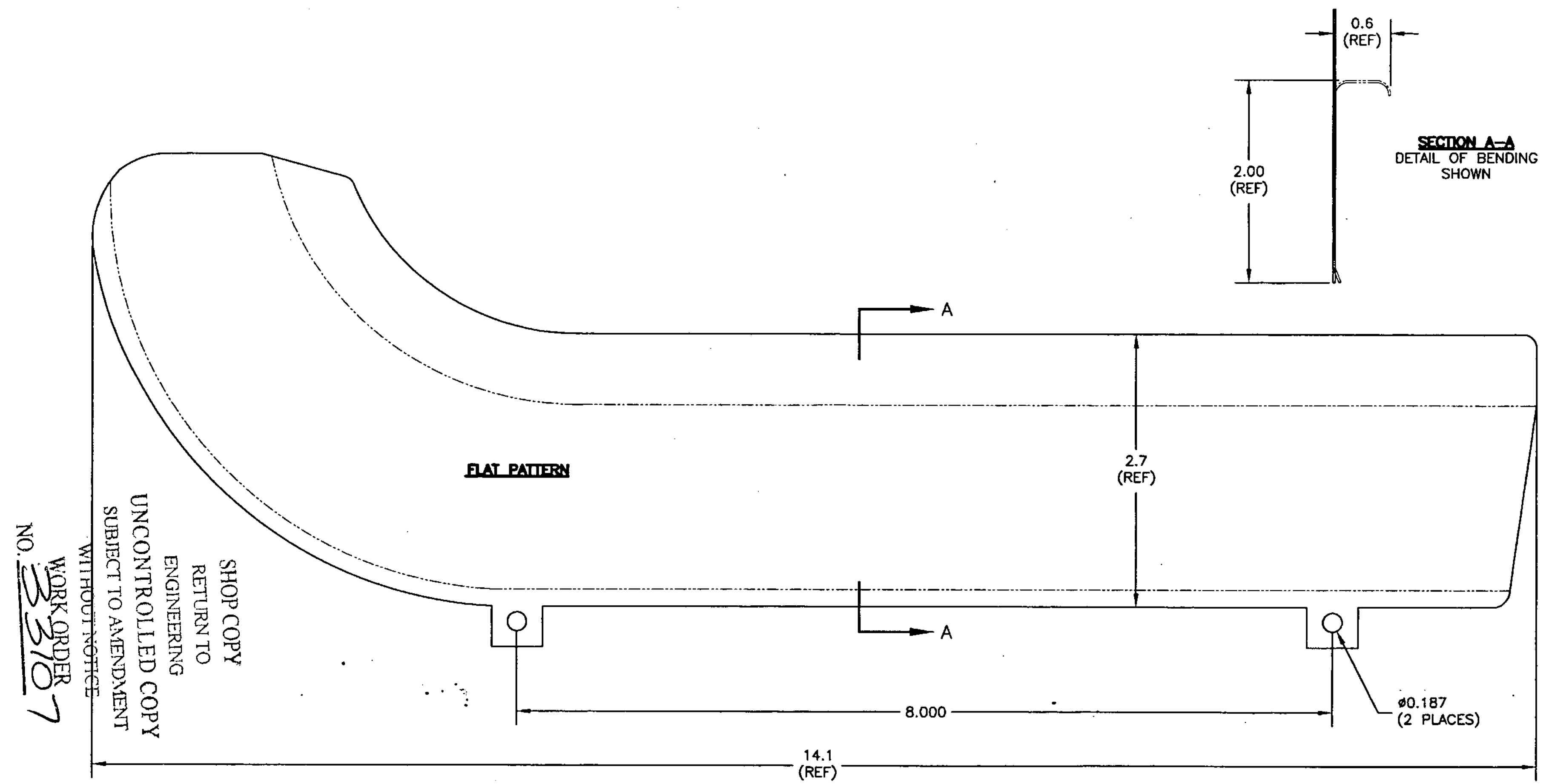
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	JB	
CHECKED: PH	APPROVED: [signature]	DRAWING NO. D206-555 REV. C SHEET 1 OF 7
DATE: 06.09.01		TITLE: DOOR SILL SCUFF PLATES SCALE: NTS

REV	DATE	DESCRIPTION
A	89.06.08	NEW ISSUE
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045
C	06.09.01	REVISED FINISH PER NCR 016

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33107

RELEASED 06.09.19

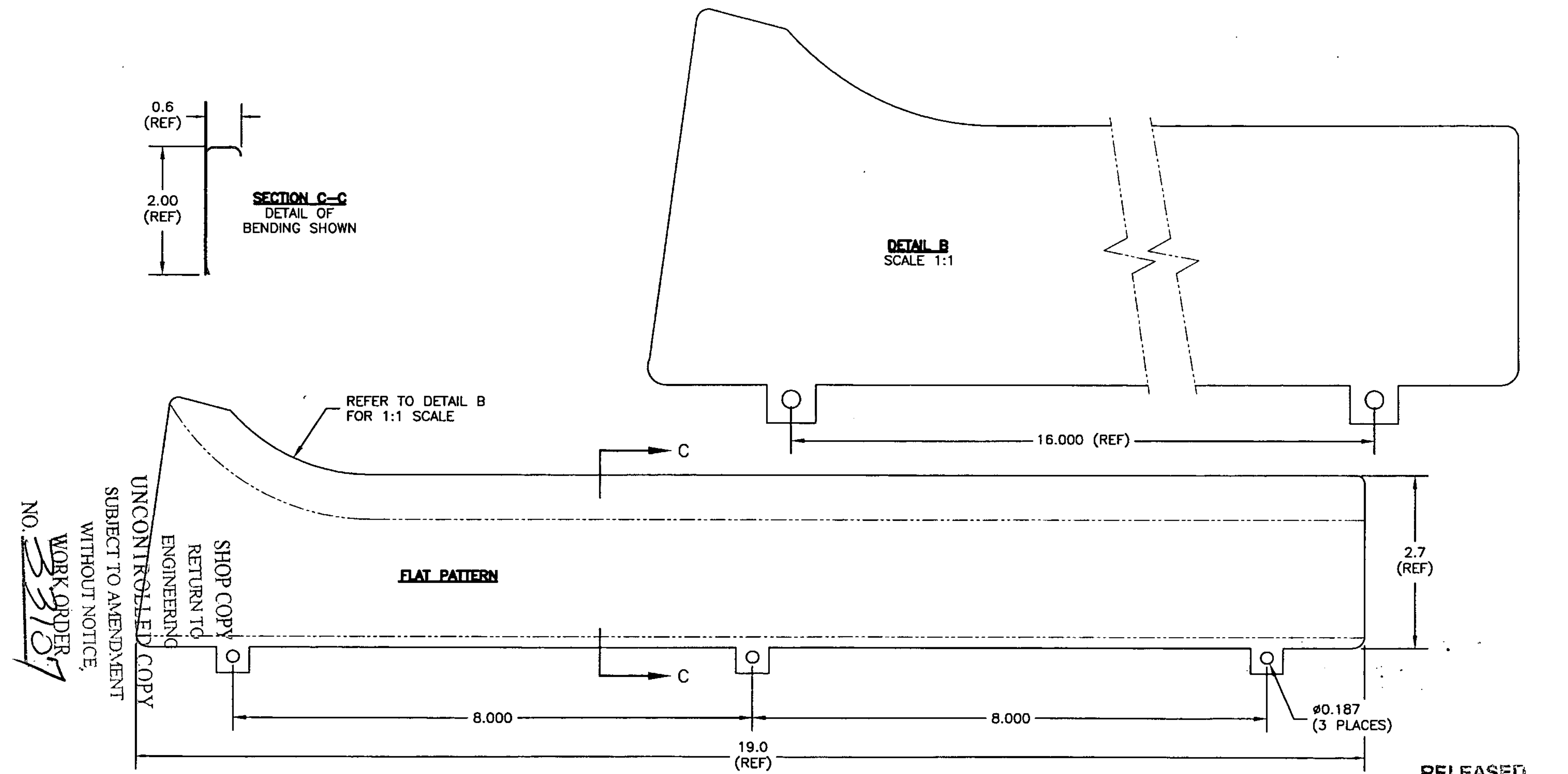


RELEASED
06.09.19

D206–555–001 (BEND IN DIRECTION SHOWN IN SECTION A–A)
D206–555–002 (BEND OPPOSITE)

NOTES
1) BEND PER M/F TEMPLATE D206–555–T1
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL–S–5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

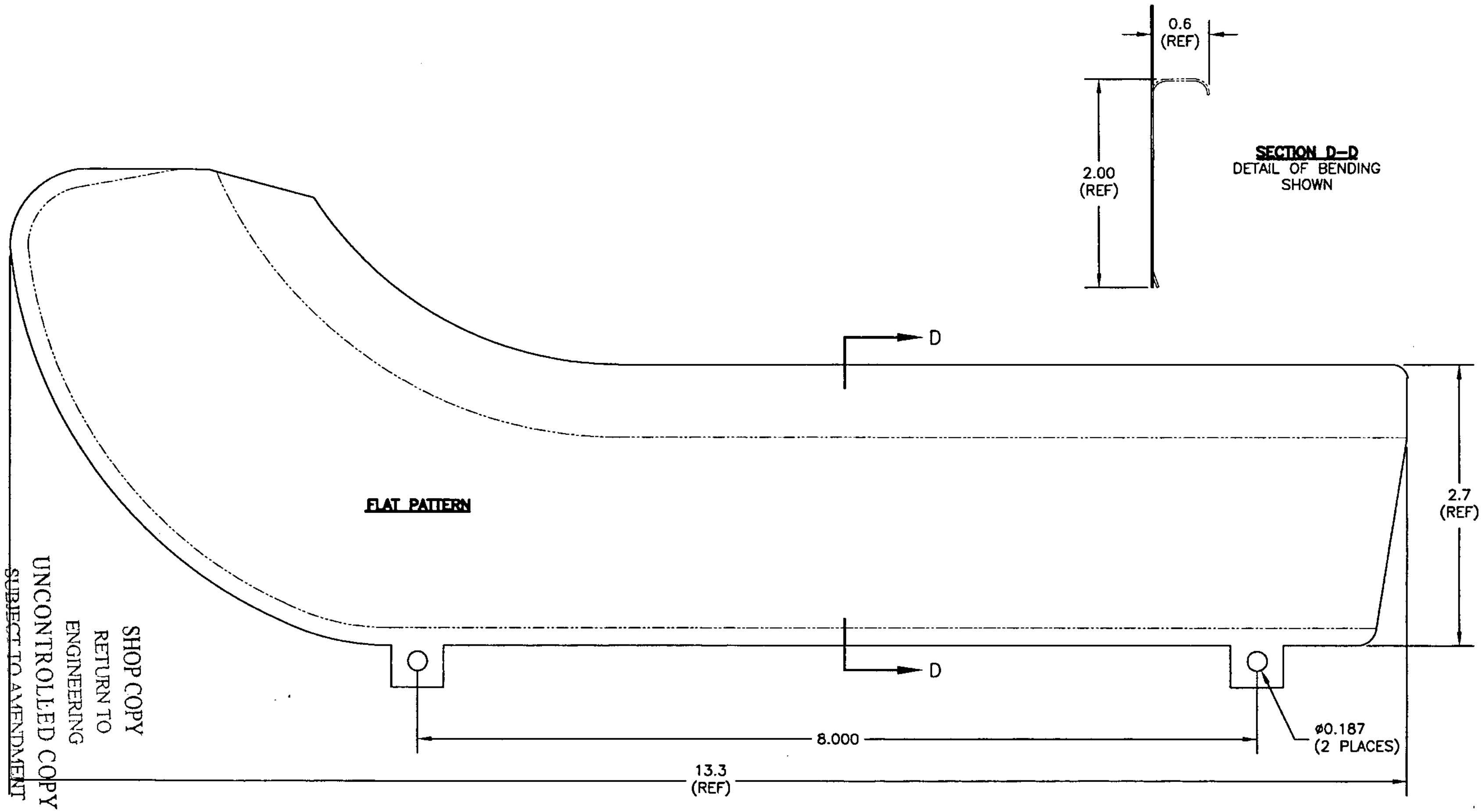
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	JB		
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	[signature]	D206–555	SHEET 2 OF 7
DATE		TITLE	SCALE
06.09.01		DOOR SILL SCUFF PLATES	1:1



D206–555–003 (BEND IN DIRECTION SHOWN IN SECTION C–C)
D206–555–004 (BEND OPPOSITE)

NOTES
1) BEND PER M/F TEMPLATE D206–555–T3
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL–S–5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

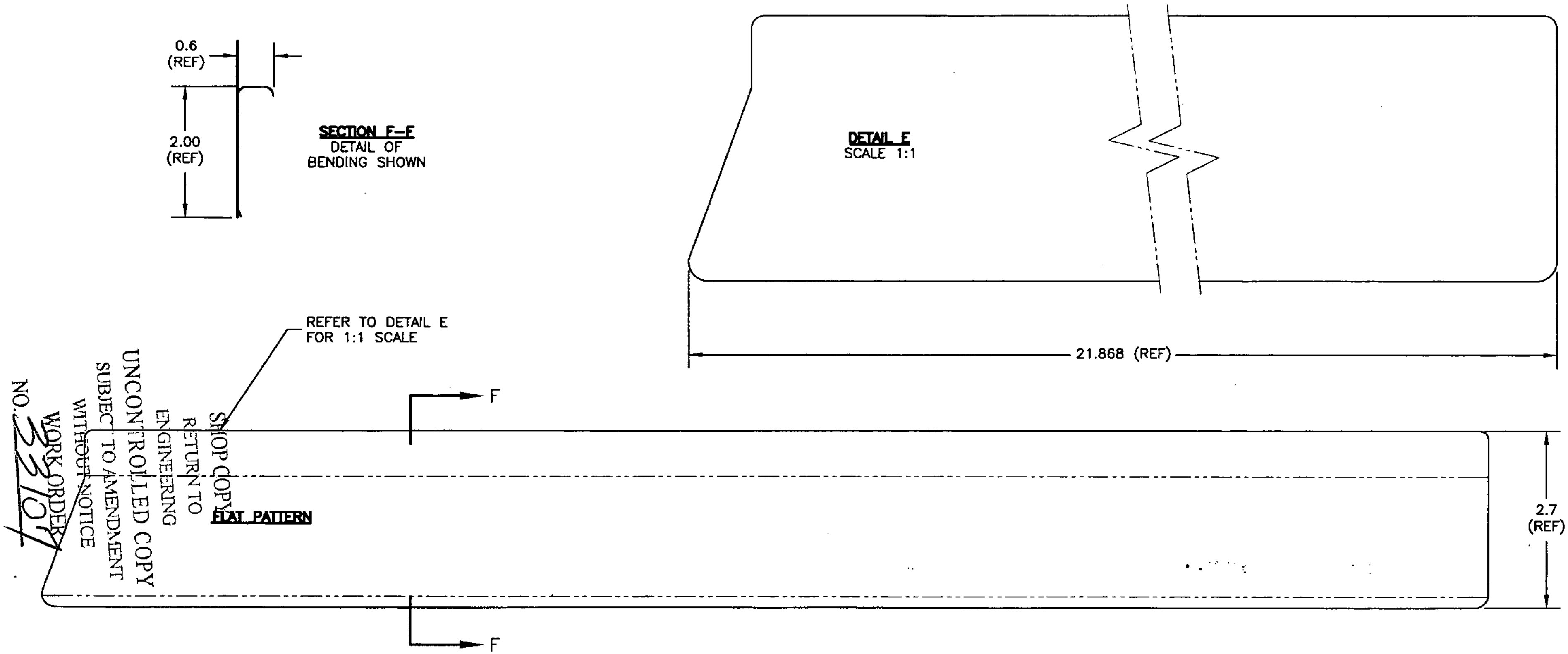
DESIGN	DRAWN BY	DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA	
JB			
CHECKED	APPROVED	DRAWING NO. D206–555	REV. C, SHEET 3 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

NOTES
1) BEND PER M/F TEMPLATE D206-555-T5
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

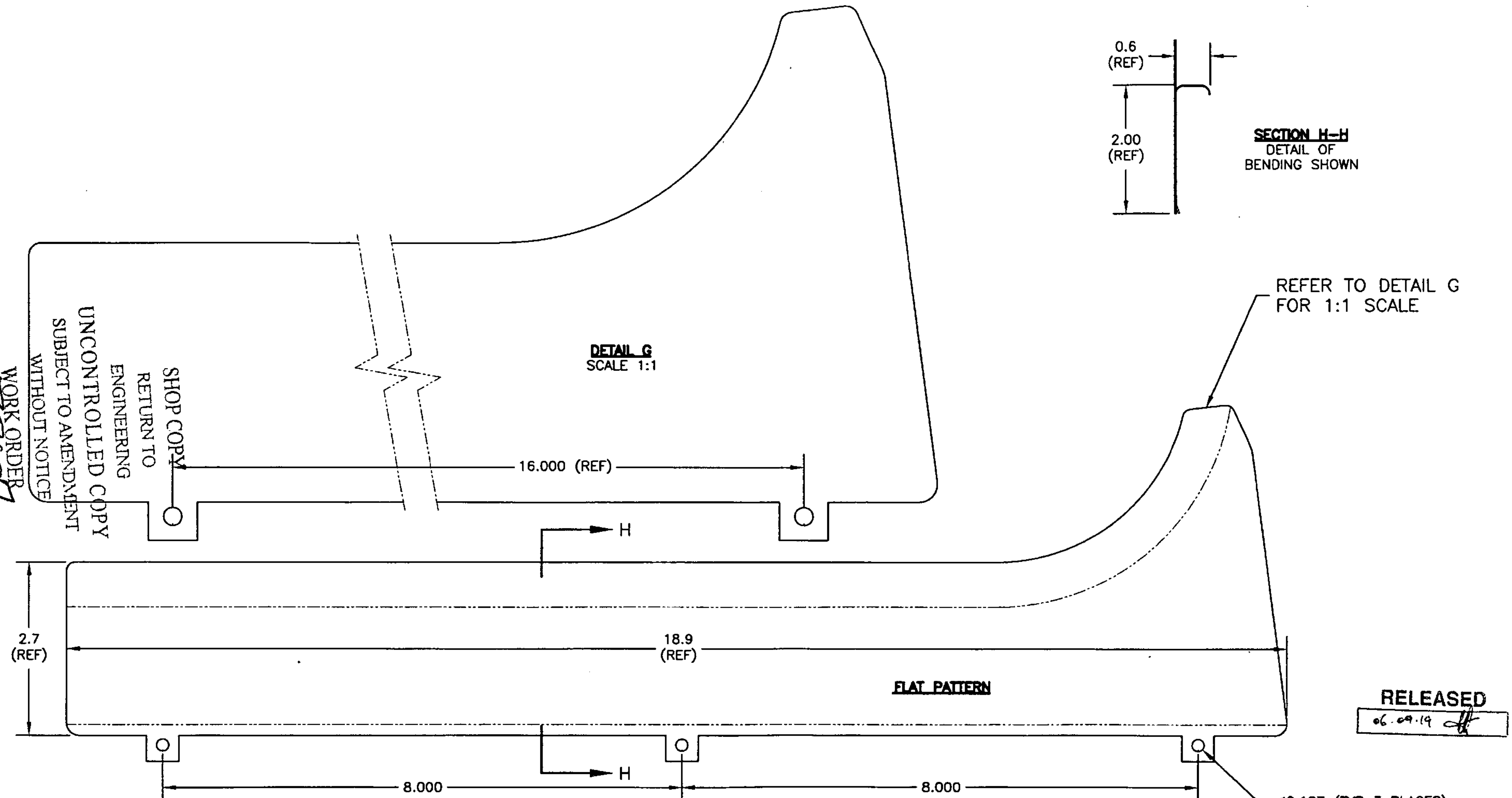
DESIGN	DRAWN BY	DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA	
JB	JB		
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	[signature]	D206-555	SHEET 4 OF 7
DATE		TITLE	SCALE
06.09.01		DOOR SILL SCUFF PLATES	1:1



D206–555–007 (BEND IN DIRECTION SHOWN IN SECTION F–F)

NOTES
1) BEND PER M/F TEMPLATE D206–555–T7
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL–S–5019 (ANNEALED) 2B FINISH
   (REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

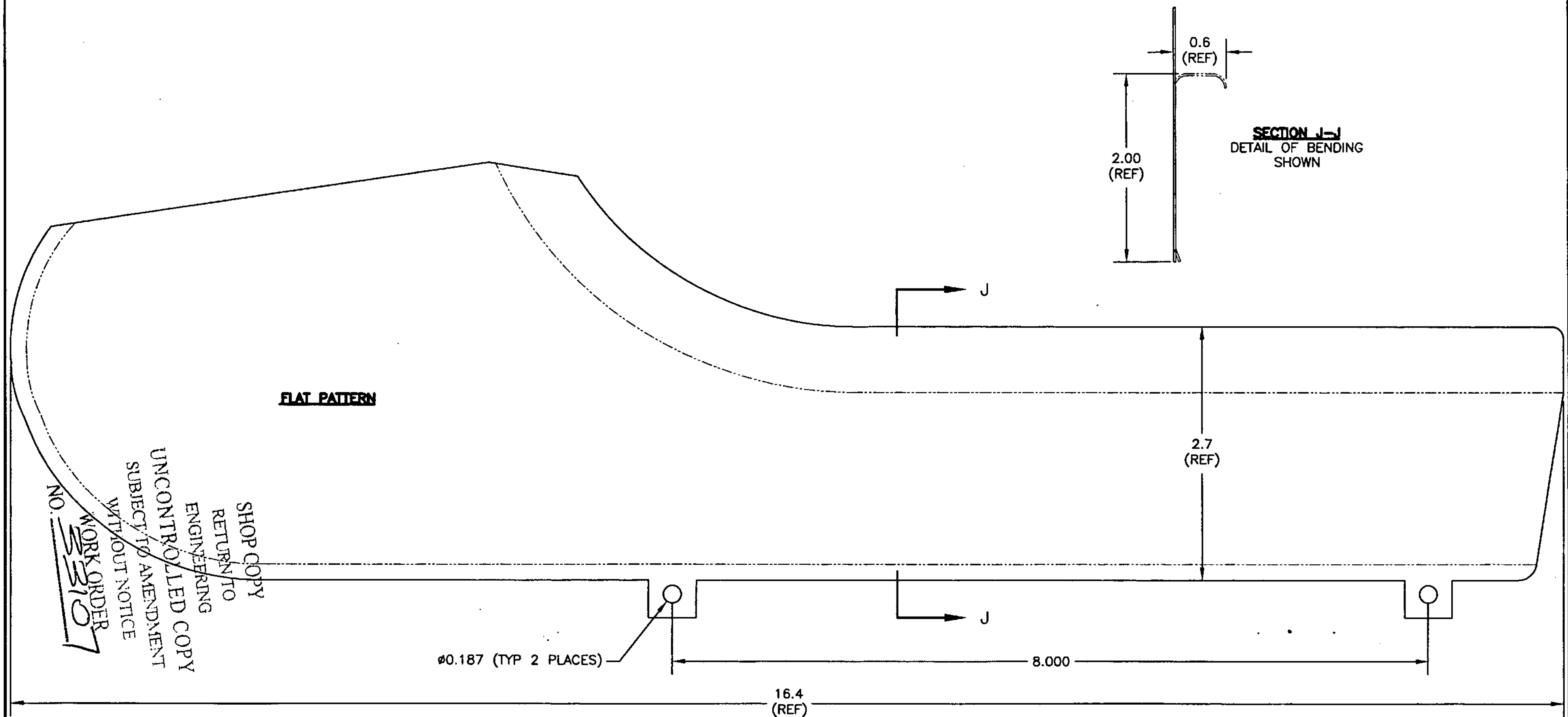
DESIGN	DRAWN BY	DART AEROSPACE LTD (HAWKESBURY, ONTARIO, CANADA)	
JB			
CHECKED	APPROVED	DRAWING NO. D206–555	REV. C SHEET 5 OF 7
PH			
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES
1) BEND PER M/F TEMPLATE D206-555-T9
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART — DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA	
JB			
CHECKED	APPROVED	DRAWING NO.	REV. C
AH		D206-555	SHEET 6 OF 7
DATE		TITLE	SCALE
06.09.01		DOOR SILL SCUFF PLATES	2:3



D206–555–011 (BEND IN DIRECTION SHOWN IN SECTION J–J)
D206–555–012 (BEND OPPOSITE)

NOTES
1) BEND PER M/F TEMPLATE D206–555–T11
2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL–S–5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD, HAWKESBURY, ONTARIO, CANADA	
JB			
CHECKED	APPROVED	DRAWING NO.	REV. C
PH		D206–555	SHEET 7 OF 7
DATE		TITLE	SCALE
06.09.01		DOOR SILL SCUFF PLATES	1:1

DART AEROSPACE LTD	Work Order: 33107
Description: 206 A/B SCUFF PLATE FWD LH	Part Number: D206555-001
Inspection Dwg: D206-555 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.1	+/- .100	14.1	✓		VERN	
2.7	+/- .100	2.706	✓		VERN	
8.000	+/- .100	8.0005	✓		VERN	
Ø .187	+.005 -.001	.188	✓		VERN	

Measured by:	HB	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	~~[illegible]~~ 07-06-27	Date:	07/08/09 07-08-09	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	